

# Work Order ID 63210

Monday, October 25, 2010 12:34:06 PM



Page 1

Item ID: D212-725-1-075F

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 10/25/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: ✓

Date: 10-10-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D212-725-1

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2024 .040

2-Deburr if necessary

B10-10-27

4

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC3- Inspect parts - second check

0.00

*8/10/10/07*



QC

Memo

0.00

Quality Control

*121 Hand Finish*  
*122 QC3*

*Acid to Alodine*

130

Identify as per dwg & Stock Location: *385*

0.00



Packaging

Memo

0.00

Packaging

\*\*\*FLAT PATTERN ONLY\*\*\*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*(x4)*

*(4) BR 10-10-08.*

*10/10/28 (4)*

*10/10/29*

*M 10-10-28*

*(4)*

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Monday, October 25, 2010 12:34:10 PM

Page 1

Work Order ID: 63210



Parent Item: D212-725-1-075F



Parent Item Name: Bracket



Start Date: 10/25/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040  2024-T3 .040 sheet		Purchased	No			100	sf	321.7400	0.1878	0.790737			
												10-10-07	

Location

Loc Qty

Loc Code

MAT

84.2

114415 \

84.2

MAT22

237.54

110305

21.93

111786

13.76

112291

28.25

112331

52

113162

121.6

114415

(4)

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

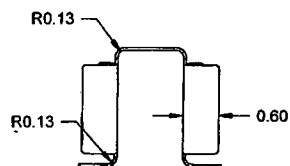
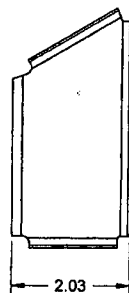
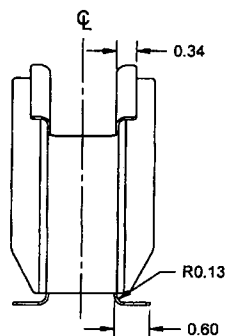
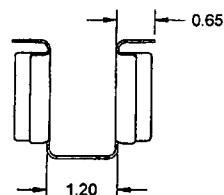
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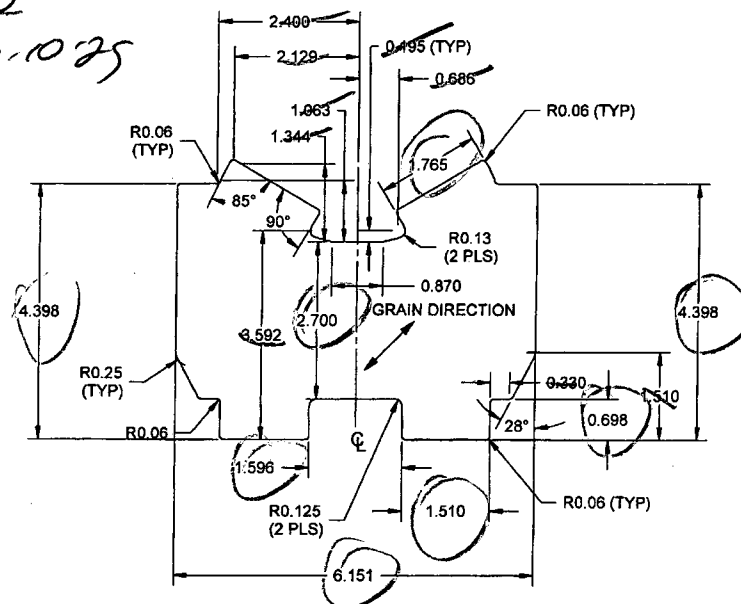
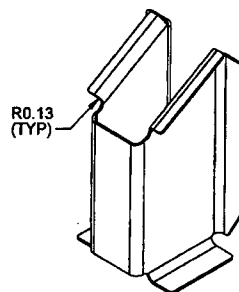
**NOTE:** Date & initial all entries



SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 63210  
*BS-10-1025*



**D212-725-1-075 BRACKET**  
(MAKE FROM D212-725-1-075F FLAT PATTERN)



**D212-725-1-075F FLAT PATTERN**

**RELEASED**  
2009-10-28

**NOTES:**

- 1) MATERIAL: 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

B	07.05.11	NO CHANGE
A	06.12.08	NEW ISSUE
DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESSBURY, ONTARIO, CANADA
CHECKED DS	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D212-725-1</b> REV. B SHEET 29 OF 44
DATE <b>07.05.11</b>	TITLE <b>212S DETAIL PARTS</b>	SCALE 1:2
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